

Work Order ID 140481

January 06, 2016 10:52:55 AM

140481

Ship Jan 21/16

Page 1

Item ID: D206-628-038 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step RH - High Gear 407
 Start Date: 1/6/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/21/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 16/1/7 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-628	G								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-038 CHG 001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS 1601-07
DAS 28
9-89 JAN 21 2016

JAN 07 2016
X2
DAS 6
9-89
JAN 21 2016

DAS 28
9-89 JAN 21 2016
2X

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D206-628-038

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step RH - High Gear 407

Start Date: 1/6/2016 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 1/21/2016 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				2X	DAS 28 9-89		JAN 21 2016
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-038								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							JAN 21 2016
140									
QC	Memo	0.00							
Quality Control									

MCS JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 140481

140481

Parent Item: D206-628-038

D206-628-038

Parent Item Name: Maintenance Step RH - High Gear 407

Start Date: 1/6/2016

Required Date: 1/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.08.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4342-042		Manufactured	No			110	Each	0.0000	1	2			
D4342-042									**	140483			
Step, RH Maintenance													
D2731-3RG		Manufactured	No			110	Each	3.0000	2	4			
D2731-3RG									**	X 140860			
Mounting Lug													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST532	3							
					109672	2							
					119202	1							
D3394-1RG		Manufactured	No			110	Each	0.0000	2	4			
D3394-1RG									**	140861			
Lug													
D4309-1		Manufactured	No			110	Each	30.0000	2	4			
D4309-1									**				
Bushing													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST091	30							
					137723	30							
AN4-12A		Purchased	No			110	Each	82.0000	4	8			
AN4-12A									**				
Bolt													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					FG	10							
					120423	10							
					ST344	72							
					m131957	72							

DAS 27 9-89

DAS 27 9-89

DAS 6 9-89

DAS 27 9-89

DAS 27 9-89

DAS 28 9-89

Picklist Print

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Work Order ID: 140481

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Parent Item: D206-628-038

D206-628-038

Parent Item Name: Maintenance Step RH - High Gear 407

Start Date: 1/6/2016

Required Date: 1/21/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A Purchased No 110 Each 285.0000 2 4

AN4-15A

Bolt

**

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 40
120449 40
ST343 245
m133284 3
m133769 242

MS21042-4 MS21042L4 Purchased No 110 Each 2.0000 6 12

MS21042-4

Nut / use MS21042L4

**

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST304 2
9063 2

NAS1149D0463J Purchased No 110 Each 2,379.000 6 12

NAS1149D0463J

WASHER

**

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 397
M129390 41
M132035 356
ST263 558
M133284 32
M133316 526
ST269 1424
M129682 39
M130799 361
M132317 101
M132677 888
M133077 35

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Shop Packet Print

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5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)